

Work Order ID 65961

Friday, January 28, 2011 11:36:32 AM



Page 1

Item ID: D4148-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Fwd

Start Date: 1/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

mf

Date: 11-01-28

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4148

C

*Pick kit**11/1/28 P*

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

11/1/28 P
11/1/28 P ①

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*11/1/28**@ Rev C**11/1/28 P*

120

Identify as per dwg & Stock Location:

468

0.00



Packaging

Memo

0.00

Packaging

11/1/28 P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 1/28/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/31 *[Signature]*
MF
11-01-28

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, January 28, 2011 11:36:28 AM

Page 1

Work Order ID: 65961

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd





Start Date: 1/28/2011

Required Date: 1/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
 IPP Rev:B 10.07.22 as per revB DD verf:JLM
 10.10.29 as per revC DD verf:EC
 IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6  Lanyard Assembly		Manufactured	No			100	Each	12.0000	1				
<div>Location</div> <div>ST020</div> <div>65617</div> <div>Loc Qty</div> <div>12</div> <div>12</div> <div>Loc Code</div>													
D3910-1  Crosstube Lug		Manufactured	No			100	Each	13.0000	1				
<div>Location</div> <div>st507</div> <div>59708</div> <div>64106</div> <div>Loc Qty</div> <div>13</div> <div>1</div> <div>12</div> <div>Loc Code</div>													
D4091-1  Mounting Lug		Manufactured	No			100	Each	7.0000	1				
<div>Location</div> <div>ST460</div> <div>62392</div> <div>Loc Qty</div> <div>7</div> <div>7</div> <div>Loc Code</div>													
D4148-1  Crosstube Lug Plate, Fwd		Manufactured	No			100	Each	1.0000	2				
<div>Location</div> <div>ST132</div> <div>63448</div> <div>Loc Qty</div> <div>1</div> <div>1</div> <div>Loc Code</div>													

11/1/08 SP

11/1/08 SP

11/1/08 SP

2
 11/1/08
 B65962 (22)

W/O:		WORK ORDER CHANGES					
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Friday, January 28, 2011 11:36:28 AM

Page 2

Work Order ID: 65961

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 1/28/2011

Required Date: 1/28/2011

Start Qty: 1.00

Required Qty: 1.00

D4148-3

 Stud Receiver, Lower

Manufactured No

100 Each

6.0000



1
 11/1/28 SP

Location

Loc Qty

Loc Code

ST132

6

63722

6

D4148-5

 Eyebolt Stud

Manufactured No

100 Each

5.0000



1
 11/1/28 SP

Location

Loc Qty

Loc Code

ENG

1

64212

1

GA

4

61005

2

63450

2

AN3C12A

 Bolts

Purchased No

100 Each

84.0000



4
 11/1/28 SP

Location

Loc Qty

Loc Code

ST351

84

112314

8

114761

11

116022

2

116289

17

116428

46

4

Friday, January 28, 2011 11:36:28 AM

Shop Packet Print

Page 2

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Picklist Print

Friday, January 28, 2011 11:36:28 AM

Page 3

Work Order ID: 65961

Parent Item: D4148-041


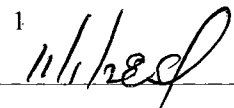

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 1/28/2011


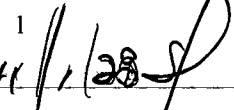

Required Date: 1/28/2011

Start Qty: 1.00


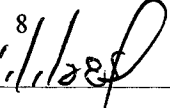

Required Qty: 1.00

AN4C13A Purchased No 100 Each 37.0000 1 1  

 BOLT


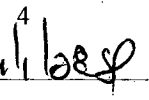

Location	Loc Qty	Loc Code
ST357	37	
113359	3	
114442	5	
114615	2	
116191	27	

MS17984-C413 Purchased No 100 Each 19.0000 1 1  

 PIN, QUICK RELEASE

Location	Loc Qty	Loc Code
ST315	19	
116706	19	

MS20615-4M18 Purchased No 100 Each 338.0000 8 8  

 Rivet

Location	Loc Qty	Loc Code
ST323	338	
114808	152	
115037	186	

MS21043-3 Purchased No 100 Each 1,611.000 4 4  

 Nut

Location	Loc Qty	Loc Code
FG	76	
103691	76	
ST301	1535	
112314	1535	

Friday, January 28, 2011 11:36:29 AM

Shop Packet Print

Page 3

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Friday, January 28, 2011 11:36:29 AM

Page 4

Work Order ID: 65961

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 1/28/2011

Required Date: 1/28/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

100

Each

1,164.000

1

1



Nut



1/1/28

Location

Loc Qty

Loc Code

ST301

1164

114523

5

114784

2

115936

261

116188

596

116549

300

NAS1149C0332R

Purchased

No

100

Each

4,540.000

8

8



Washer



1/1/28

Location

Loc Qty

Loc Code

ST297

4540

115000

125

115698

35

116025

1380

116304

3000

NAS1149C0432R

Purchased

No

100

Each

154.0000

2

2



Washer



1/1/28

Location

Loc Qty

Loc Code

ST297

154

114292

36

114742

27

116304

91

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

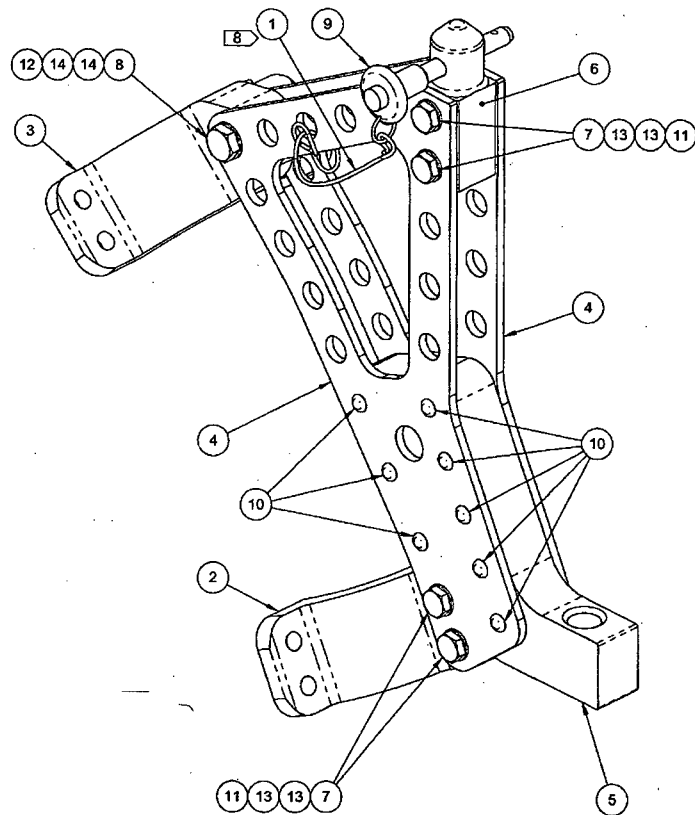
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4148-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.63 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

ITEM	QTY	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	4	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	4	MS21043-3	NUT
12	1	MS21043-4	NUT
13	8	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER

05901

RELEASED
2010-10-28

C	REDESIGNED D4148-1/-3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); QTY 2 PL REPLACES QTY 3 PL (ZN D6-3); QTY 129 7 PL WAS 10 PL (ZN A7-3); QTY 191 WAS 0.129 (ZN C5-5); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4148** REV. C
SHEET 1 OF 5

TITLE **FWD X-TUBE LUG ASSY** SCALE NTS

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8 7 6 5 4 3 2 1

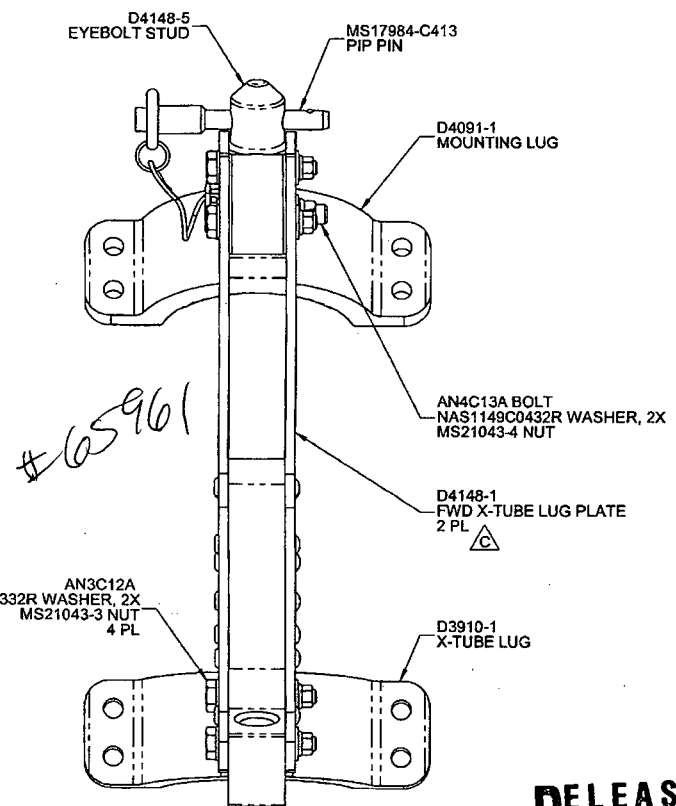
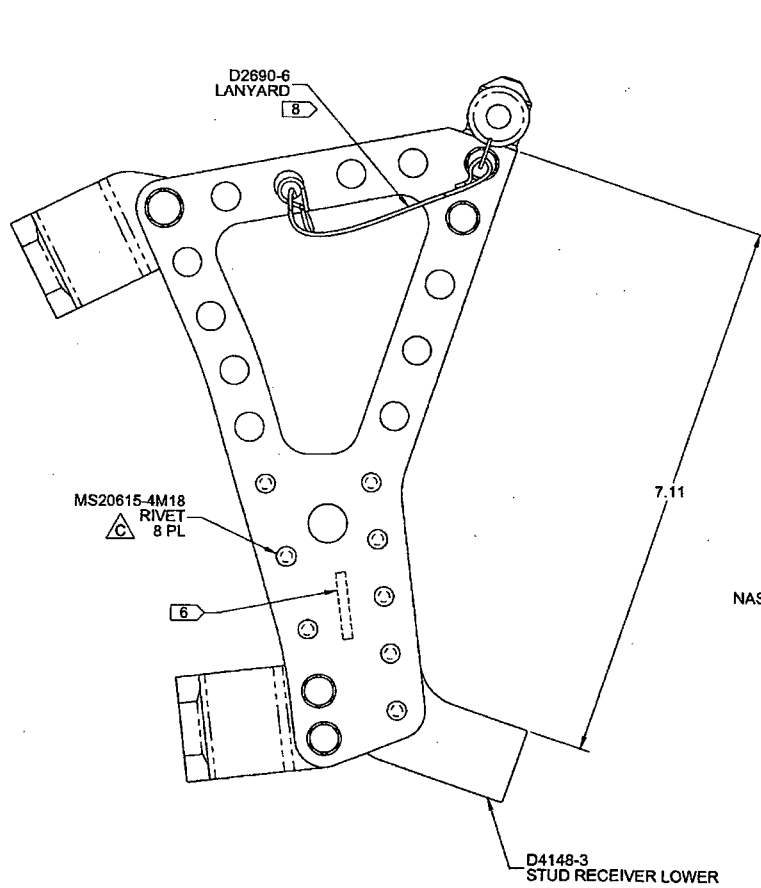
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NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY

RELEASED
2010-10-28

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO. D4148	REV. C
MFG. APPR.		SHEET 2 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
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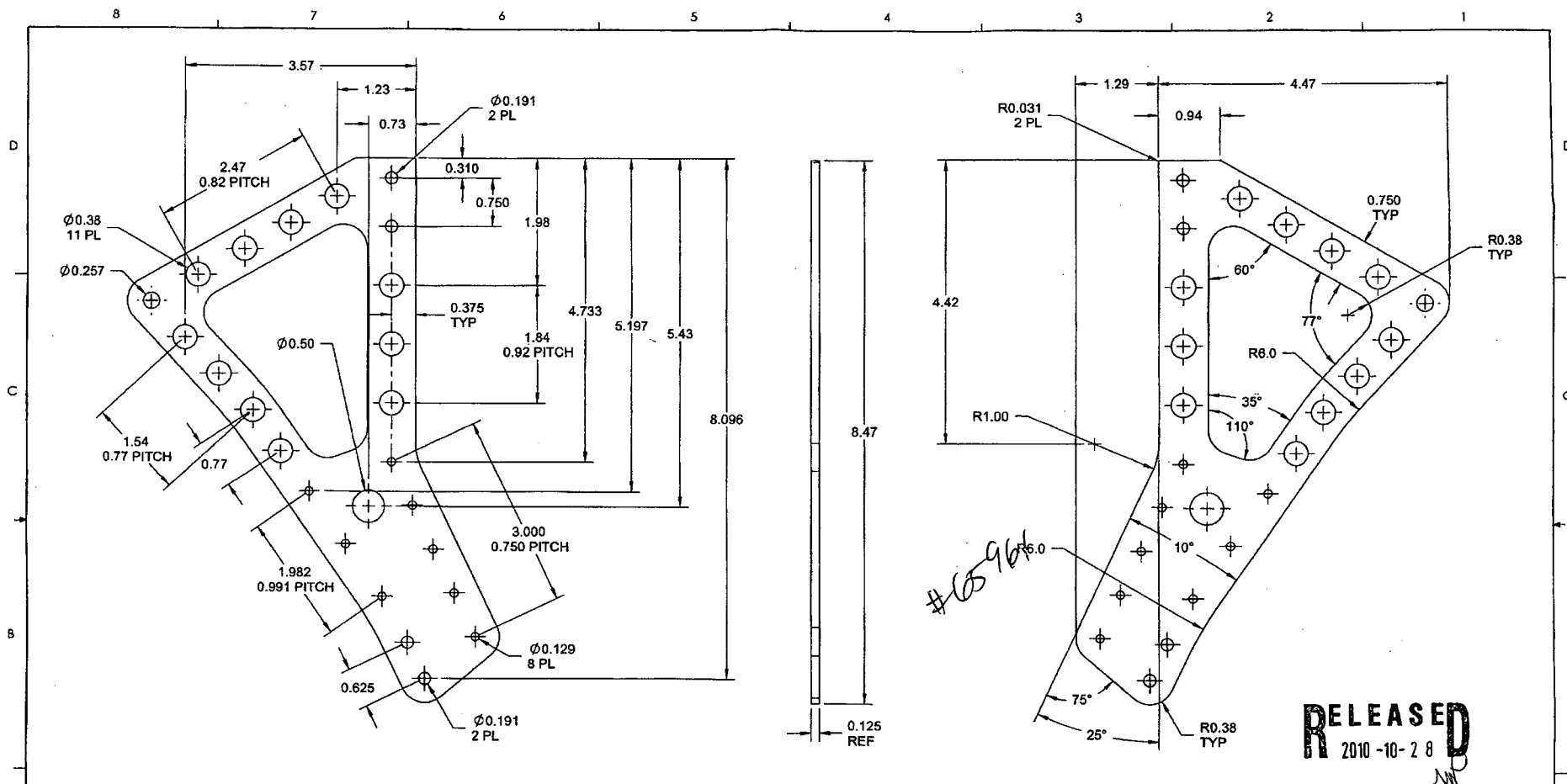
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D4148-1 FWD X-TUBE LUG PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-8059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.52 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4148	REV. C
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE FWD X-TUBE LUG ASSY	SCALE
DE APPR.			NTS
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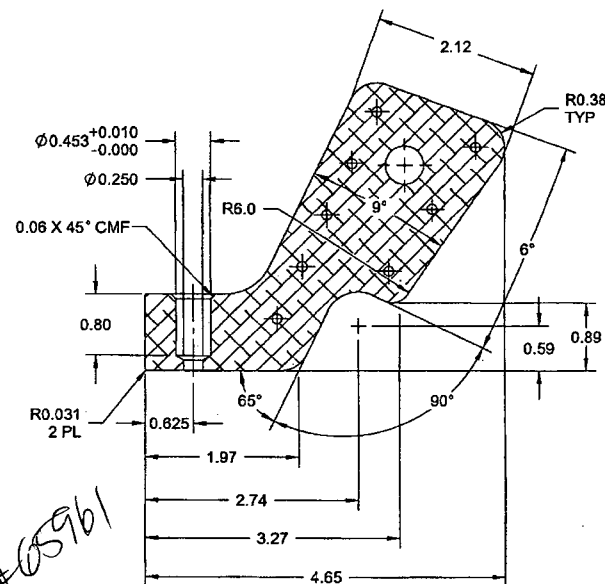
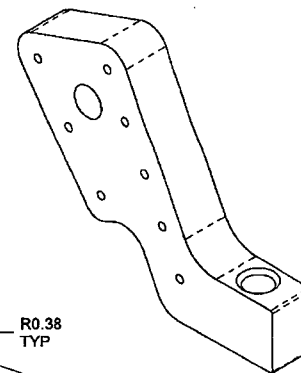
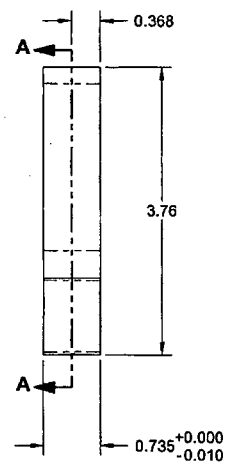
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RELEASED
2010-10-28

#05961

1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B

2) FINISH: NONE


3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 1.52 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. #
MFG. APPR.		D4148	SHEET 4 OF 4
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DE APPR.		FWD X-TUBE LUG ASSY	NT
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W/O:		WORK ORDER CHANGES					
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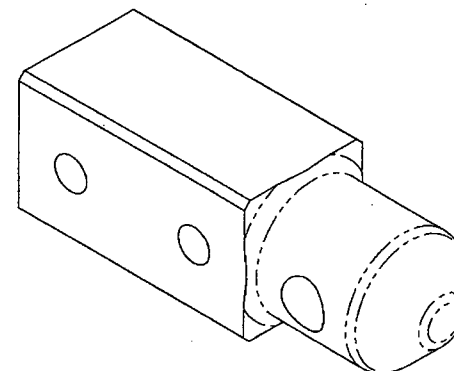
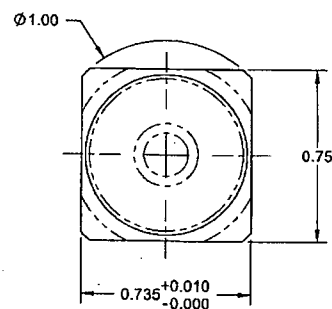
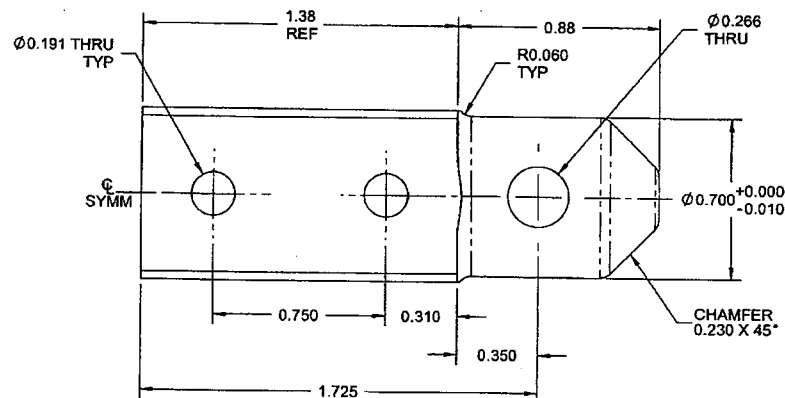
8 7 6 5 4 3 2 1

D

C

B

A



D

C

B

A

D4148-5 EYEBOLT STUD

#65941

RELEASED
2010-10-28

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4148	SHEET 5 OF 5
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8 7 6 5 4 3 2 1

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